

Date: Thursday, 2/21/2008 9:26:05 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 37565
 Estimate Number : 10531
 P.O. Number :
 This Issue : 2/21/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2572
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2572 REV E
 Previous Run : 37283 Drawing Revision : E
 Material :
 Due Date : 3/15/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : 08/02/21
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: B31388 +1

08/02/27

10

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 81 Double check by: 8F

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

8F 08/03/25

P10

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



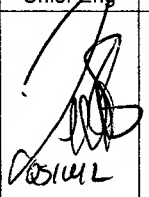
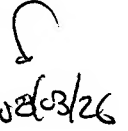
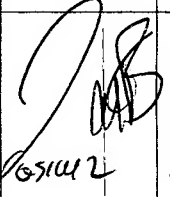
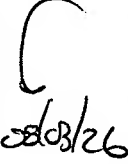
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8F 08/03/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / machined part NCR: Yes No DQA: D Date: 08/04/15
2412-742 QA: N/C Closed: D Date: 08/04/15

NCR: <u>37565</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/26	2.0	One saddle IS scrap because the hole location is off by .050" The dimension of .500 ± .010" was .438		Scrap and destroy AND Replace <u>Qty 10</u> B# <u>31388</u>	08/03/26			
		R.C. Origin was not take properly. operator error.						

NOTE: Date & initial all entries

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Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37565

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

20 08/04/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/04/02

(10X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BL

08-04-03

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-04-07

(X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STG32

08/04/03

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W 08/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 37565
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.441	.441	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.000		
F	0.490	0.510		.501	.500	.502	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.257		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.502	.500	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.573	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.885	3.875	3.874	3.874		
P	0.115	0.135		.126	.127	.127	.127		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.126	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.962		
V	0.230	0.250		.233	.234	.237	.240		
W	0.115	0.135		.130	.130	.125	.125		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.389	1.388	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.253		
AH	0.240	0.260		.246	.249	.249	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: RF
Date: 08/03/25

Audited by: RF
Date: 08/04/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 37565
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	62	73	84	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.502	.503	.503	.502		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.376	.376		
I	0.490	0.510		.505	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.577	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.130	.130	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.961		
V	0.230	0.250		.239	.240	.239	.240		
W	0.115	0.135		.135	.130	.130	.130		
X	0.307	0.312		.309	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.384	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.248	.250	.250	.250		
AH	0.240	0.260		.257	.257	.240	.240		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>RF</i>
Date: 08/03/27

Audited by: <i>RF</i>
Date: 08/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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F	0.490	0.510		.502	.501				
G	0.257	0.262	DT8683	.258	.260				
H	0.375	0.380	DT8684	.377	.378				
I	0.490	0.510		.501	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.590	.570				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.499				
O	3.869	3.879		3.874	3.872				
P	0.115	0.135		.126	.125				
Q	0.115	0.135		.127	.135				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.127	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.960				
V	0.230	0.250		.240	.241				
W	0.115	0.135		.127	.120				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.760	.766				
Z	0.352	0.372		.362	.365				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.630	.625				
AC	0.053	0.073		.060	.063				
AD	0.240	0.260		.250	.250				
AE	1.375	1.395		1.385	1.384				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.255	.253				
AH	0.240	0.260		.250	.252				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

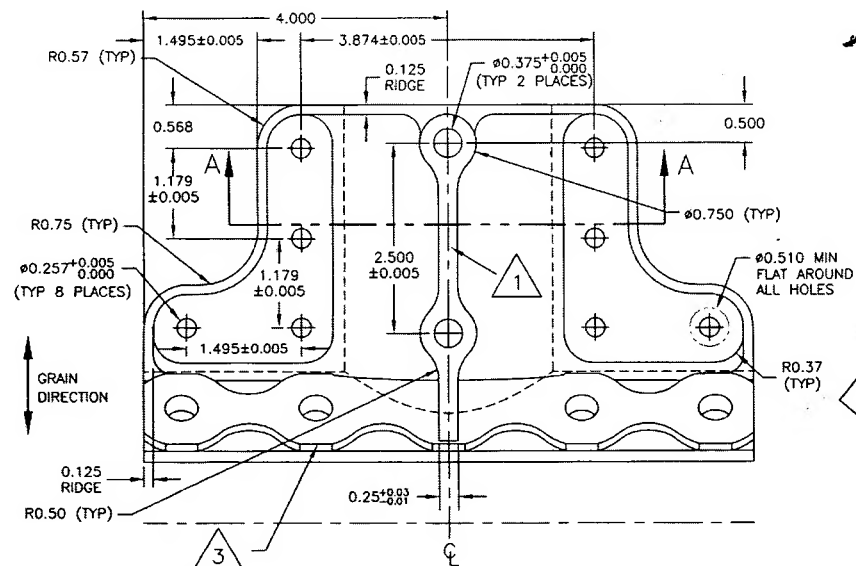
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Date: <u>08/03/28</u>

Audited by: <u>RF</u>
Date: <u>08/04/02</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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RELEASED

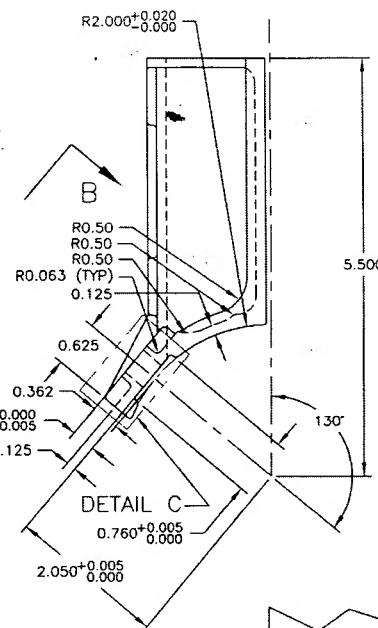
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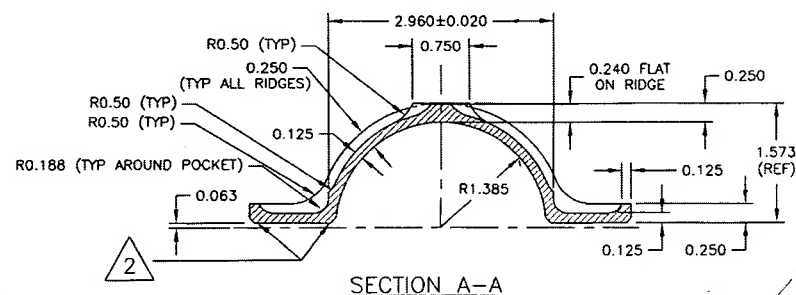
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

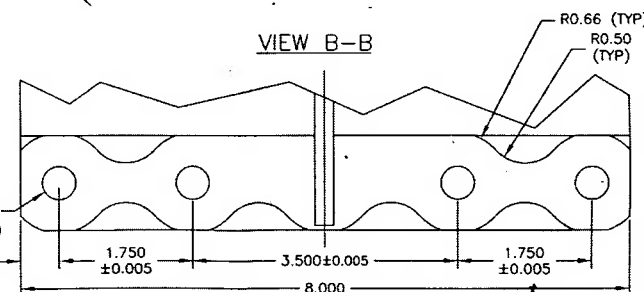
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C



SECTION A-A



VIEW B-B

DETAIL C
SCALE 2:1

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 DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2572
		TITLE INNER FWD SADDLE
		SCALE 2:3

DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

REV. E

SHEET 1 OF 1

NO. 37565
 WORK ORDER
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 RETURN TO
 SHOP COPY
 ENGINEERING